

Work Order ID 60837

Monday, July 26, 2010 9:46:52 AM



Page 1

Item ID: D3442-3

Accept



Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 7/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

14

Date:

10-7-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3442

Rev A

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3442
Deburr if necessary

☐ Dwg Rev:

A

☐ Prog Rev:

A

☐ 2-

HB 10-7-28

304, 037

(4)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

HB 10-7-28

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

Scrap 120

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60837

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Page 2

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Required Date: 7/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: *WA*

0.00

SAD

Memo

0.00

*10-07-28**(4)*

Packaging

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*10/07/29**10-7-28*
(4)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 9:46:57 AM

Page 1

Work Order ID: 60837

Parent Item: D3442-3

Parent Item Name: Shim





Start Date: 7/26/2010

Required Date: 7/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.09.02 New issue KJ/JLM
IPP B 07.07.23 waterjet EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA  304/316 .032 Sheet		Purchased	No			100	sf	30.7896	0.025	0.105263			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>4MAT20</div> <div>30.7896</div> <div></div> </div> <div> <div>109023</div> <div>30.7896</div> <div></div> </div>													
											 <div>109023</div>		

1310-7-28

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

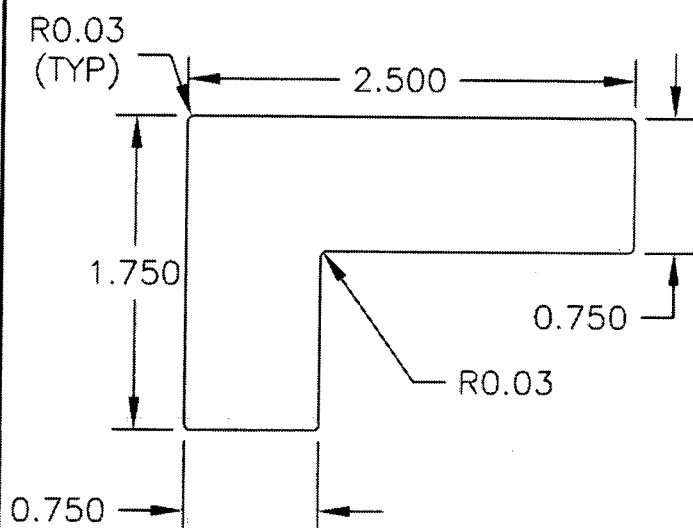
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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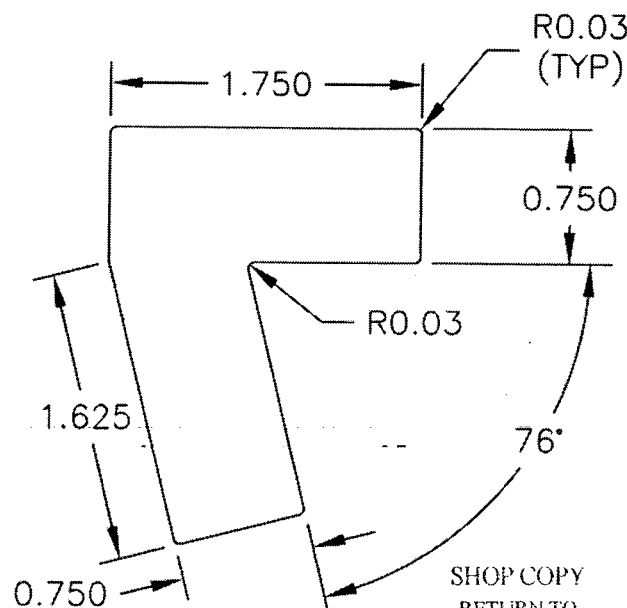
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03		TITLE SHIM	SCALE 1:1
A	05.06.03	NEW ISSUE	



D3442-1



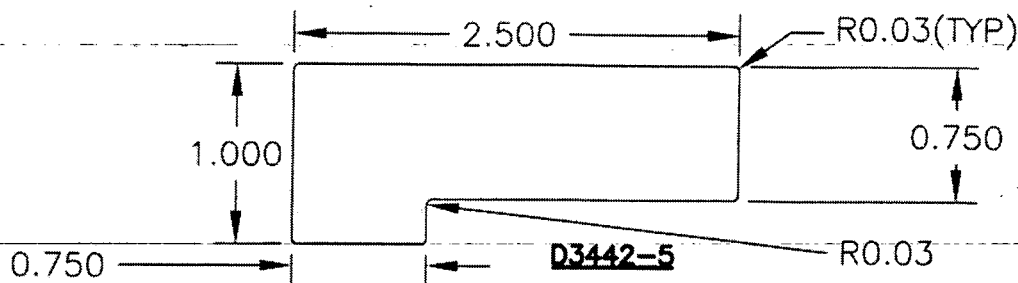
D3442-3

D3442-1/-3 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET -21 GAUGE (0.034 THICK)
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60837

BS10-7-26



D3442-5

D3442-5 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.08.19 *[Signature]*

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